

Work Order ID 52414

Page 1

September 23, 2009 1:55:39 PM

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

DC


0.00

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-541
CHG003N/A 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

September 23, 2009 1:55:40 PM

Reference:

Item Name: Replacement Skidtube

Start Qty: 1.00

Cust Item ID:**Required Date:** 10/08/09**Req'd Qty: 1.00****Customer ID:****Customer Name:****Approvals:**

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence
ID

**Work
Center ID**

Operation Description

Set Up

Run

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

Insp.
Stamp

110

Skidtubes

0.00

0.00

Skidtubes

Memo

Skidtubes

1- Bend FWD end of tube using bend prog D3274
FWD dwg D3274, cut fwd end of tube with saw table
setup D3274.

2- remove fwd indexing ridge as per dwg D3274.
Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004
AR Aluminum Rod Batch: 4109213

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

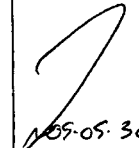
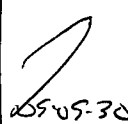
6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

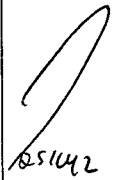



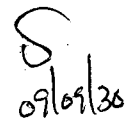
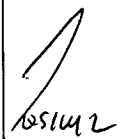



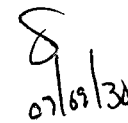
8 -Remove inner indexing ridge on aft end of skidtube
as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

$\textcircled{P_{10}} \rightarrow$

W/O: 52414		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.9.30	110.4	Add a note to verify & inspect the material prior to use, per NCR below.	AB	09/10/09		 09.09.30	 09.09.30	

Part No: D206-642-541 PAR #: N/A Fault Category: Skidhuber NCR: (Yes) No DQA: AB Date: 09.11.06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AB Date: 09.11.18

NCR: 52414		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/09/08	#110.4	Employee Found A Long Dent on bottom of tube. R.L. manufacture/Transport it wasn't noticed before before	 09/09/08	- Dent is too large to be fixed Also it is right in middle of tube. cannot be saved	 9-10-1	 09/10/08	 09/09/08	 09/09/30
		welding or Bending	 09/09/08	Scrap and Destroy Replace on this w.o. B 47575 Qty 1	 9-10-1	 09/10/08	 09/09/08	 09/09/30

NOTE: Date & initial all entries

Work Order ID 52414

September 23, 2009 1:55:45 PM

Page 3

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09 **Start Qty:** 1.00

Cust Item ID:

Required Date: 10/08/09 **Req'd Qty:** 1.00

Customer ID:

Customer Name:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

September 23, 2009 1:55:45 PM

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Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

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Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Skidtubes

0.00

0.00

Skidtubes

Memo

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R [] Sikaflex-291 [] 1112391 []

Sikaflex expire date: [] 2010/02/30

Start: [] 9-10-8 [] Time: [] 2 PM []

Finish: [] 9/10/13 [] Time: [] 12:00 PM

(Adhere for 12 hours)

9-10-8

160

QC

QC5- Inspect part completeness to step on W/O

0.00

0.00

Quality Control

Memo

2) 502/10/13

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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TE: Date & initial all entries

Work Order ID 52414

September 23, 2009 1:55:56 PM

Page 6

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	Skidtubes	0.00	0.00							
		Memo 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod. A/R: Aluminum Rod <u>M109213</u> 3-Grind cross bolt welds flush as per Dwg D3274. 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.									
200	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control	Memo									
210	QC	QC10- Inspect visual per QSI004- ground welds	0.00	0.00							
	Quality Control	Memo									
220	HandFinish	Pressure Wash per QSI005 4.3	0.00	0.00							
	Hand Finishing	Memo									

BE 09/10/15

AWM 9-10-19.

AWM 9-10-22

2) 8/10/22

(X)

2) 8/10/22

(X)

2) 8/10/22

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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September 23, 2009 1:55:56 PM

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:**Required Date:** 10/08/09**Req'd Qty: 1.00****Customer ID:**

Customer Name:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum Memo: 11/12260 START TIME: 1:30pm OVEN TEMPERATURE: 320°C FINISH TIME: 2:00pm ⇒ 9/10/22	0.00	0.00				21	0		
240	QC Quality Control	QC3- Inspect Part Finish Memo: LMD 09/10/27	0.00	0.00				21			
250	HandFinish Hand Finishing	HandFinishing 1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets. A/RIN/A LPS-3U 2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a A/RIN/Sikaflex-291 11/12391 Sikaflex expire date: 10/20	0.00	0.00				21			
260	QC Quality Control	QC5- Inspect part completeness to step on W/O Memo: Inspect Nut Plate & Inserts 25 09/10/22	0.00	0.00				21	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 52414

September 23, 2009 1:55:56 PM

Page 8

Item ID: D206-642-541

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Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270

HandFinish

0.00

0.00

Hand Finishing

Memo

HAND FINISHING RESOURCE #1

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☒ m112391

Sikaflex expire date: ☐ 10/20

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 1/1

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☒ m112391

Sikaflex expire date: ☐ 10/20

LPS PROXYON Batch: m104251

mp 09/10/27

280

QC

0.00

0.00

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

278 09/10/27

Ⓢ

290

Packaging

0.00

0.00

Packaging

Memo

Identify as per dwg & Stock Location: PDP

52879

10/14/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52414

Page 9

September 23, 2009 1:56:02 PM

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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300	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
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Quality Control

Memo

09/10/28
PL 09-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:17 PM

Page 1
12

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-190RevD1		Manufactured	No			110	Each	74.0000	1.0000			
												
Extrusion Round 3" 206												

D9-9-29

D3285-1RevA		Manufactured	No			110	Each	34.0000	12.0000			
												
Cap												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	74	
47575	74	

(1)

D3282-041RevC		Manufactured	No			150	Each	10.0000	1.0000			
												
Float Web (206L/407)												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
47635	34	

86 02/09/06

1 PD 09.09.30

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	10	
48389	10	

D9-10-5

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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September 23, 2009 1:55:17 PM

Page 2

Work Order ID: 52414



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	711.0000	1.0000			



Cross Bolt Spacer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	83	
51529	83	
Main Warehouse		
ST	628	
36013	5	
47112	383	
48271	240	

D3275-1RevA1

Manufactured No

190

Each

100.0000

12.0000



Crossbolt Spacer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	100	
47464	1	
48117	43	
48270	56	

12 BE 09/10/14

48 BE 09/10/14

September 23, 2009 1:55:17 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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September 23, 2009 1:55:17 PM

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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CR3212-4-03		Purchased	No			250	Each	314.0000	2.0000			
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Cherry Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 314

111359 96

112314 200

15984 18

D3415-041RevB		Manufactured	No			250	Each	95.0000	1.0000			
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Nut Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 95

33842 95

CCR264SS3-3		Purchased	No			250	Each	271.0000	2.0000			
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Cherry Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 271

111548 56

111827 115

112314 100

X2 mo 09/10/27

X1 mo 09/10/27

X2 mo 09/10/27

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September 23, 2009 1:55:18 PM

Page 4

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Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,439.000	78.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

110511

5439

5439

270

Each

43.0000

1.0000

D3536-15RevA

Manufactured

No



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

47711

48159

51600

43

5

12

26

X 78 mo 09/10/27

X 1 mo 09/10/27

September 23, 2009 1:55:18 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:18 PM

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3536-23RevA

Manufactured

No

270

Each

32.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

12

51609

12

Main Warehouse

ST

20

30754

1

47713

19

D3536-35RevA

Manufactured

No

270

Each

41.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

48160

15

51628

26

X1 MD 09/10/07

X1 MD 09/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:19 PM

Work Order ID: 52414



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube



Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-39RevA		Manufactured	No			270	Each	30.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 12

51637 12

Main Warehouse

ST 18

44648 1

47714 6

48161 11

D3535-15RevB

Manufactured No

270

Each

15.0000

1.0000



Wearshoe

XI

MD 09/10/27

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 15

30750 4

42233 1

48155 10

XI

MD 09/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:20 PM

Page 7

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-35RevB		Manufactured	No			270	Each	12.0000	1.0000			
												
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

12

48157

12

D3535-39RevB

Manufactured

No

270

Each

15.0000

1.0000



Wearshoe

XI umo 09/10/27

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

15

47525

2

48158

13

D3535-23RevB

Manufactured

No

270

Each

13.0000

1.0000



Wearshoe

XI umo 09/10/27

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

13

48156

13

XI umo 09/10/27

September 23, 2009 1:55:20 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:20 PM

Page 8

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-3RevC

Manufactured

No

270

Each

72.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

30758

8

33881

17

35697

47

D3537-1RevC

Manufactured

No

270

Each

192.0000

9.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

30

48288

2

50321

28

Main Warehouse

FP17

162

51678

162

1351624

X1 umd 09/10/09

X9 umd 09/10/09

September 23, 2009 1:55:20 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:28 PM

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			270	Each	6,864.000	80.0000			

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 100


103585 100

Main Warehouse

ST 6764

112116 1764

112612 5000

AN960C416  washer		Purchased	No			270	Each	706.0000	1.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 706

100993 706

X80 UMD 09/10/09

X1 UMD 09/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:28 PM

Page 10

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube



Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-IRevB		Manufactured	No			270	Each	1,186.000	2.0000			
												
Phenolic Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 686

39275 19



42329 121

47628 546

Main Warehouse

ST117 500

51674 500

AN3C4A		Purchased	No			270	Each	1,976.000	80.0000			
												
BOLT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1976

112082 14

112314 140

112612 146

112720 1176

112724 500

412794

x2 mo 09/10/27

x80 mo 09/10/27

September 23, 2009 1:55:28 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:55:33 PM

Work Order ID: 52414

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4C5A Purchased No 270 Each 603.0000 1.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 603

104936 19

110552 82

112243 500

18918 2

D2646RevC Manufactured No 270 Each 56.0000 1.0000



Aft Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 56

20208 0

43801 1

46327 6

48109 49

XI MO 09/10/27

XI MO 09/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

September 23, 2009 1:55:34 PM

Work Order ID: 52414



Parent Item: D206-642-541RevM



Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3413-1RevA		Manufactured	No			270	Each	22.0000	1.0000			



Ring



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
48123	22	

XI MD 09/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY SCALE NTS	
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

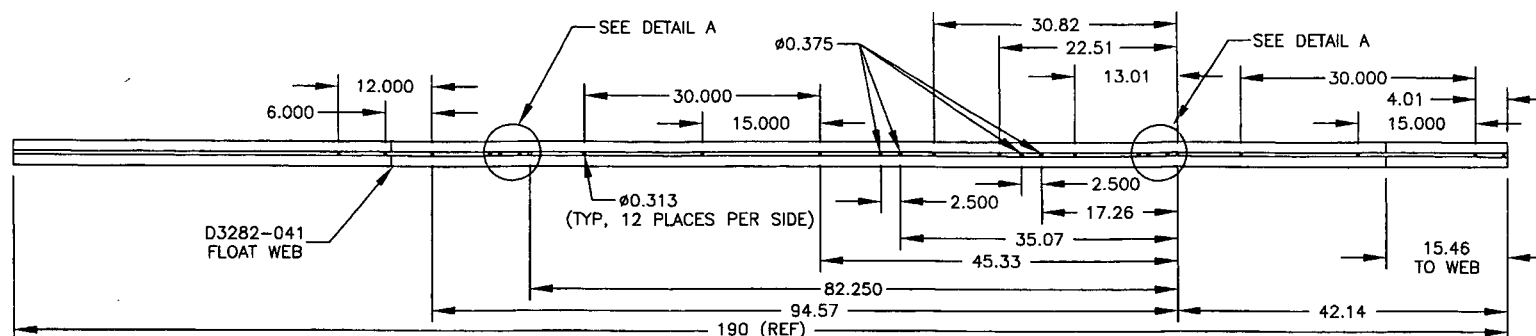
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

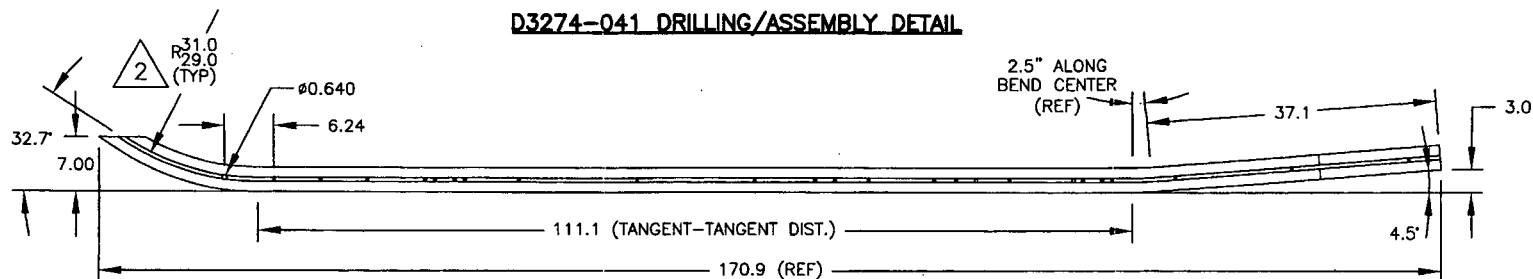
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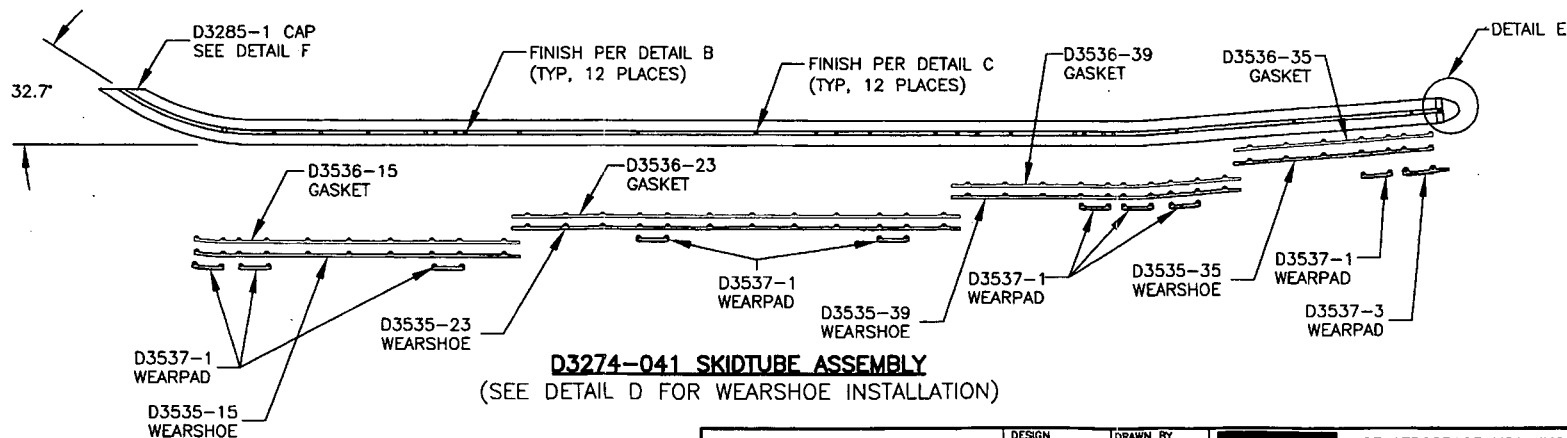
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



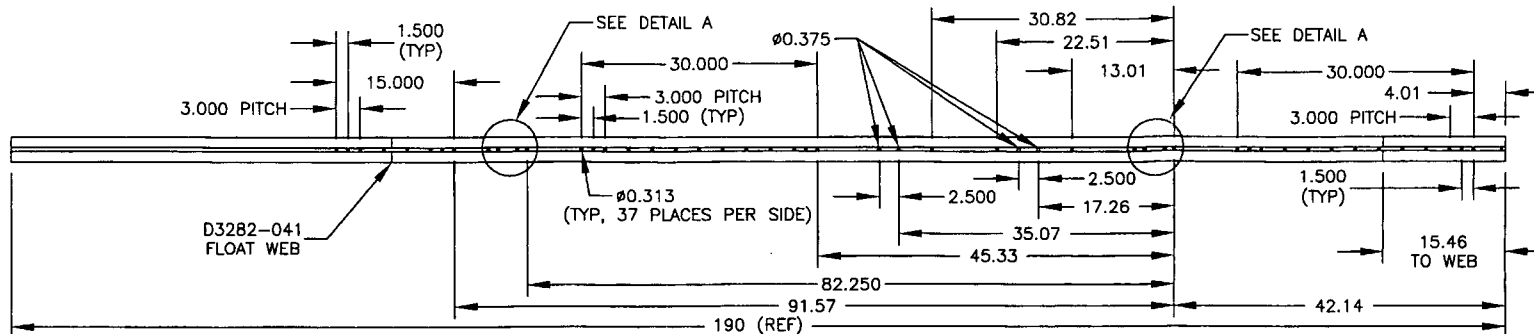
D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

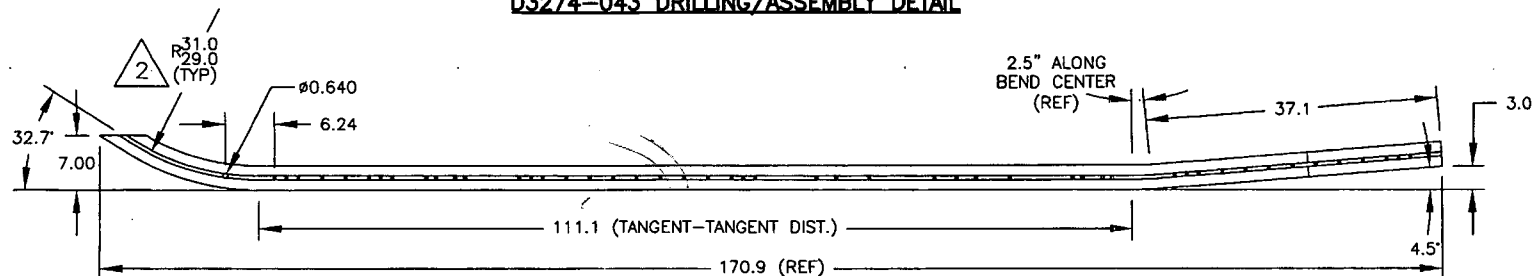
07.02.12

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CHECKED	CP	APPROVED	PH	DRAWING NO.	REV. D
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY		
				SHEET 2 OF 4	SCALE
				1:15	

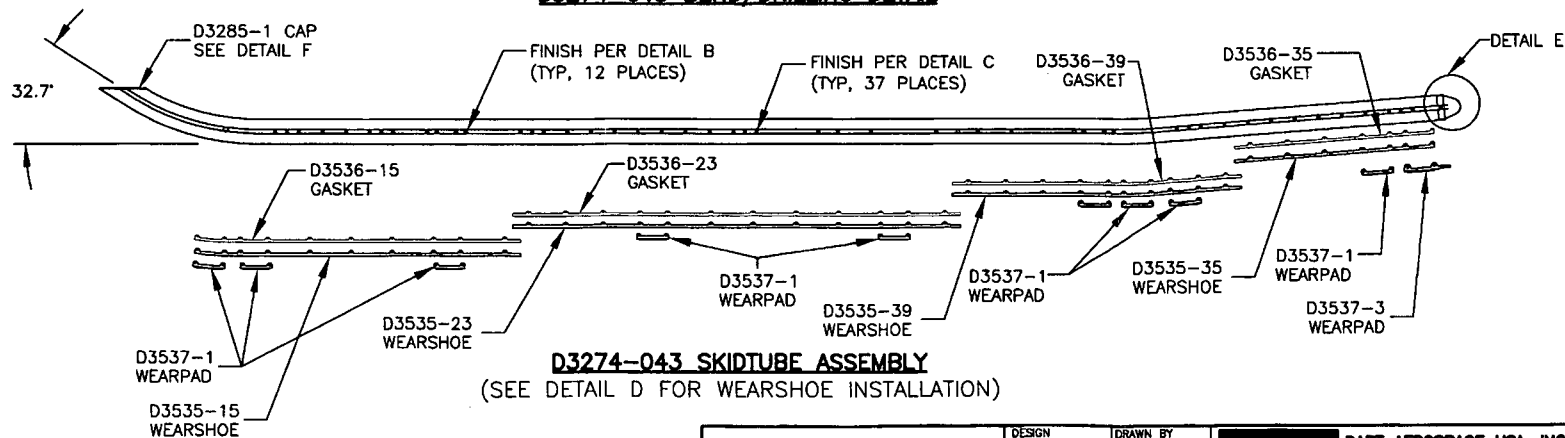
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



RELEASED

07.02.12

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DESIGN

6N

DRAWN BY

DART

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

CHECKED

KEP

APPROVED

DRAWING NO	
------------	--

REV. D

DATE _____

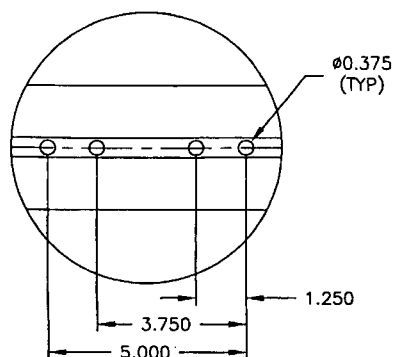
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SKIDTUBE ASSEMBLY

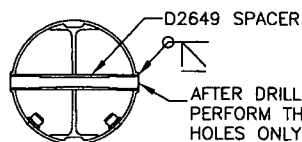
SCALE

1:15

DETAIL A: DRILL DETAIL

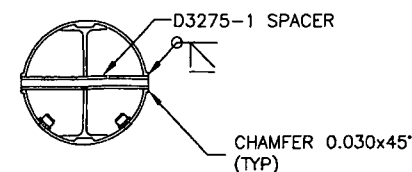


DETAIL B FOR 0.375 HOLES ONLY

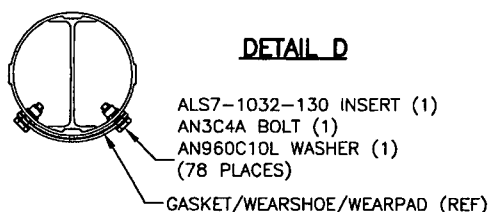


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

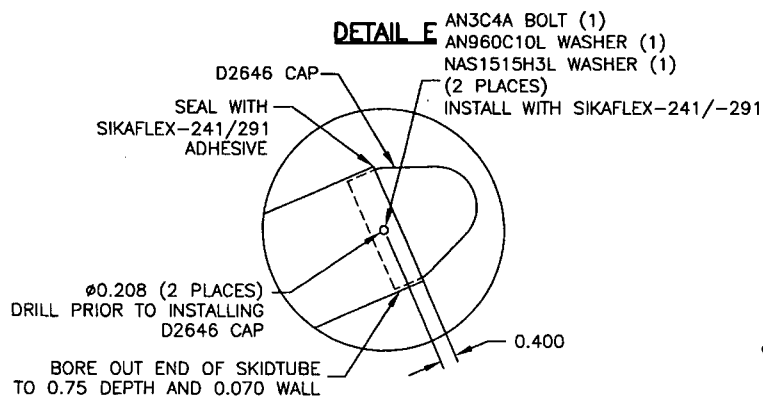
DETAIL C FOR 0.313 HOLES ONLY



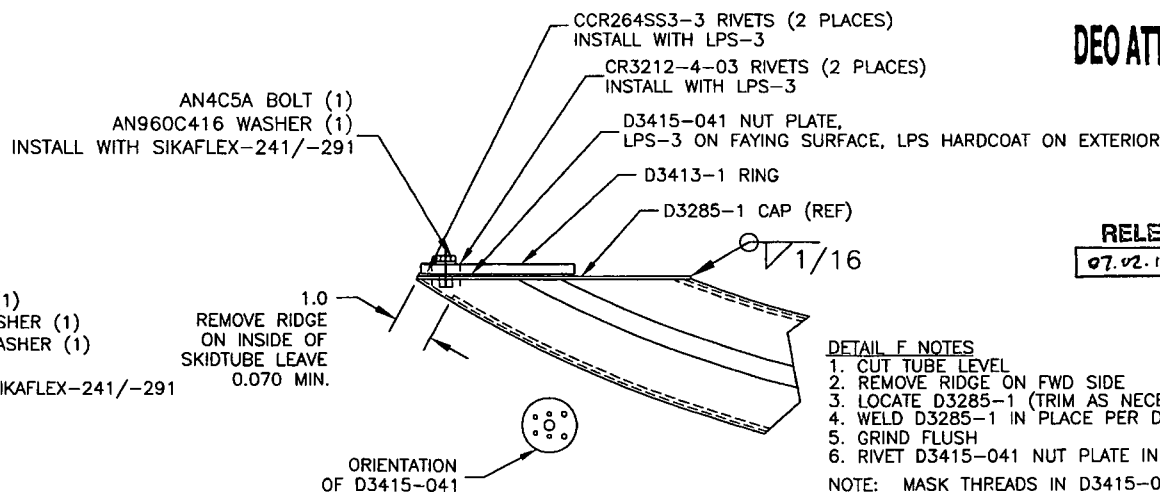
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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CHECKED	APPROVED	CP	PH	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	
				REV. D SHEET 4 OF 4 SCALE 1:3

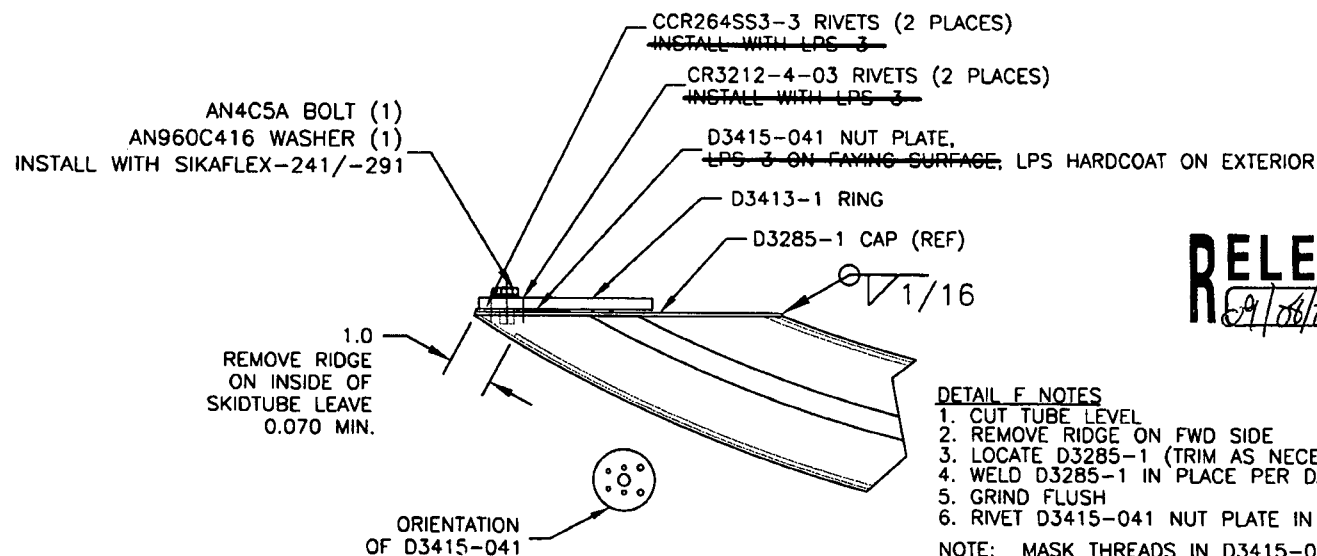
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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NO. 211

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52411
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier Pct. Paul

Date of Test Coupon 09-10-09

Welder Barclay Elliott

Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld